

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011551**Date Inspected:** 15-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** Watson Bowman Acme**Location:** Amherst, New York**CWI Name:** John Miller, Greg Ross**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Seismic Joint (Hinge AW & AE)**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Watson Bowman Acme (WBA) facility in Amherst, New York for the purpose of observing Procedure Qualification Record (PQR) test fabrication of the Seismic Joint (Hinge AW & AE).

WBA Shop- (PQR-Fillet test #3):

QA Inspector Brannon witnessed WBA welder Mr. Mike Armitage welding Procedure Qualification Record (PQR) number FCAW-fillet weld soundness. QA Inspector Brannon observed WBA QC CWI Mr. John Miller monitoring the PQR test. Mr. Armitage deposited one pass on the FCAW-fillet weld soundness test. QC Mr. Miller performed visual inspection on the test plate after the first pass and rejected the fillet weld soundness test. Note: Reference document Request For Information (RFI) ABF-RFI-002017R00.

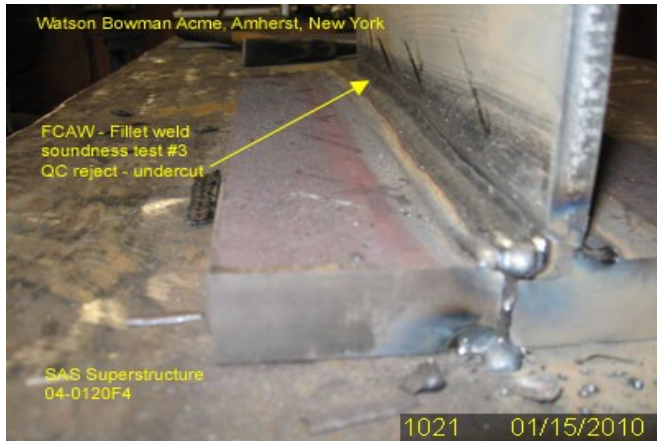
WBA Shop- (PQR-1G):

QA Inspector Brannon traveled with and QC Inspector Mr. Greg Ross to Analytical Services, Inc. for the purpose of transporting Figure 5.2 WPS Verification - Test Plate B for qualifying PQR - NY-WBA-08-3J to laboratory for Radiography Testing (RT). Later in the day QA inspector Brannon was informed by QC Mr. Greg Ross that the Figure 5.2 WPS Verification - Test Plate B test plate had failed RT testing. Note: Reference document Request For Information (RFI) ABF-RFI-002017R00.

The following digital photograph below illustrates observation of the activities being performed.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey, (510) 301-0162, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
